

Work Order ID 72102

Tuesday, July 19, 2011 11:14:36 AM

Page 1

Item ID: D3622-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ball Stud

Start Date: 7/19/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 7/19/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3622

Rev C

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622 ,
FOLIO REV: C
DWG REV: 11/8/15
2-DEBURR AS REQUIRED

30 ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

5/11/8/15

30 ✓

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ant 4/08/15

30 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72102

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Page 2

Item ID: D3622-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 7/19/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>70</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/15 *[Signature]* 30

11/8/15 *[Signature]*

MF
11-08-15

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Picklist Print

Tuesday, July 19, 2011 11:14:42 AM

Page 1

Work Order ID: 72102



Parent Item: D3622-1



Parent Item Name: Ball Stud



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	71.1300	0.108	3.410526			
												7/15/11	
303 HEX BAR .500													

Location

MAT037

109778

Loc Qty

71.13

71.13

Loc Code

3.41 RT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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
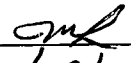
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	72102
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.585	/		SA 9	
0.50	+/-0.030	.500	/			
Ø0.394	+/-0.010	.3945	/			
Ø0.310	+/-0.010	.310	/			
Ø0.215	+/-0.010	.217	/			
0.155	+/-0.010	.150	/			
0.313	+/-0.010	.313	/			
0.478	+/-0.010	.478	/			
0.630	+/-0.010	.630	/			
0.125	+/-0.010	.130	/			
0.563	+/-0.010	.565	/			
1.19	+/-0.030	1.19	/			
0.3125-24UNF-3A	+0.000/-0.032		/			
M.O.W.	Min = 0.3336 Max = 0.3363	.3345	/			

Measured by:		Audited by:		Preliminary Approval:	
Date:	11/8/15	Date:	11/08/15	Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ 	

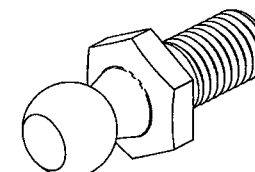
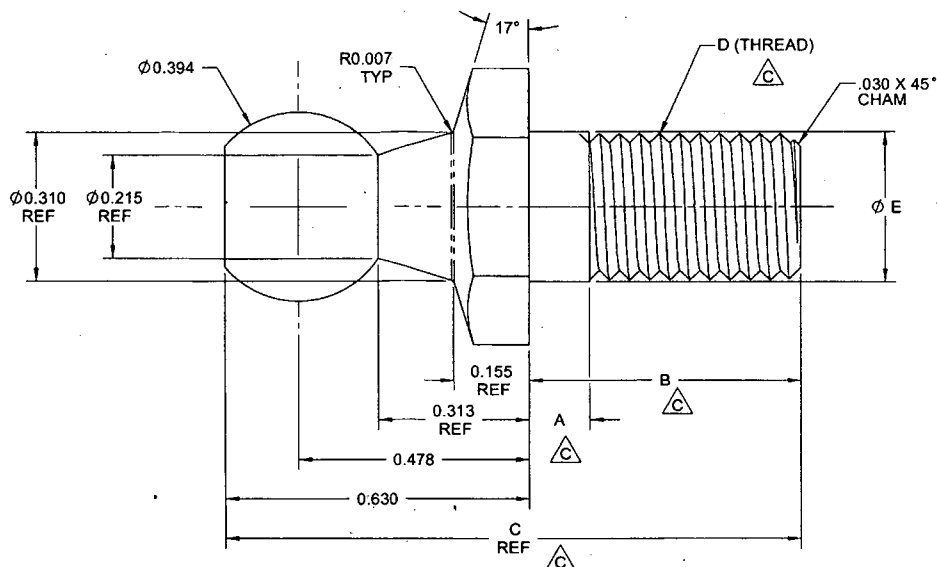
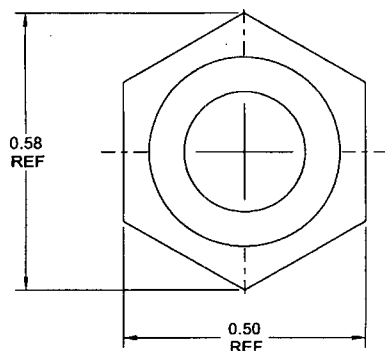
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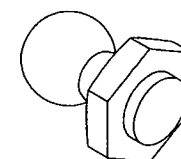
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NOTE: Date & initial all entries



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM		DIM C	WEIGHT (LBS)	THREAD D	Ø E	
	A	B				MIN	MAX
D3622-11	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

- NOTES:**
- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
 - 7) WEIGHT: SEE D3622-X TABLE

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72102**

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3622	REV. C
MFG. APPR.		TITLE BALL STUD	SHEET 1 OF 1
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.07.20		

RELEASED
2010-09-23

W/O:		WORK ORDER CHANGES					
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